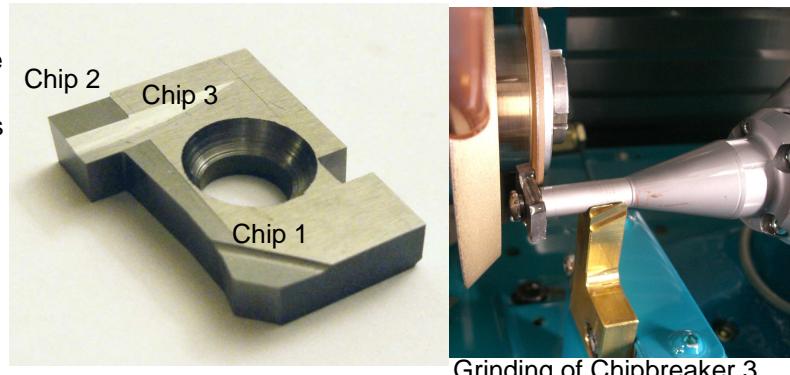


Singlesided Insert with ref. Notch

A8-300

The rectangular Insert is clamped using the PPC System (Precision Pin Clamping). All the sides are free for any grinding of profile, chipbreaking or referenceface operations. This specific inserts has 3 different chipbreaker faces and a reference notch. All of them are ground in one and the same cycle. Profilegrinding is based on the VSW grinding technology, where the sides of the V-shaped wheel fit tangential to the straight faces and convex parts of the profile.



Grinding of Chipbreaker 3

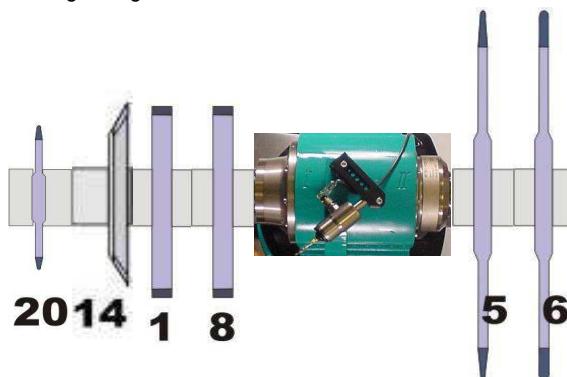
1. Cycletime for production

Tool specifications 20x16x4 mm, Length of profile edge 20 mm Material HM									
Operations	Probe	Prf Rough	Prf Pregr	Prf fin	bottom	notch	chip 1	chip 2	chip 3
Feed [mm/Min]	2000	25	85	110	60	60	60	60	60
Power [kW]		2	1	1	1	1	1	1	1
Cutting feed [m/s]		18	24	30	18	18	18	18	18
Used wheels		1	5	6	14	8	14	14	20
Grinding time [s]	13	116	57	42	48	43	64	59	33
Total cycle time	7 Min 55								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

- 1 Ø125 1A1 D64
- 5 Ø300 14EE1 D91
- 6 Ø300 14EE1 D46
- 14 Ø125 1V1 D64
- 8 Ø125 1A1 D64
- 20 Ø75 14EE1 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 4.2, DXQ-Insert

responsible engineer: OP, 7.2.07

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